Work Orde				*928	324*							Page
Item ID: Revision ID: Item Name:	D3913-041 Long Basket B	ase Assemby, 350	A	Accept	*N900	<b>040</b>	100	<b>)</b> * s	Setup S	tart top	*N:	S1*
Start Date: Required Date: Reference:	11/09/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					. 1 11 1	
Approvals:		n: <u>M</u> LJ		Tooling: SPC (Y/N):		ate:		j		tart stop	*NI *NI	R1* R2*
Sequence ID/ Work Center II	0	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Jumber	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3913 D4020	В			·								
*100 *100* Large Fab Large Fab		Large Fab  Memo 1- assemble	e ribs, weld as per dwg D39 before welding mesh***	0.00 0.00 3 using DT9610A	GC	13.4.	22					
		and trim mo	20-1 base mesh and tack weldesh to fit if necessary and tringe (3) and Mounting brackets to locate hinge and bracket*	n to clear fasteners hole s as per dwg D3913		~ 6	Nl	13-	04-2	⊋		

110

QC9- Inspect visual per QSI004- Fusion Welds

4- Weld D4672-1 blanking plates as per dwg

0.00

\*110\*

Memo

0.00

13-04-24

DYS)

Quality Control

											DQA:	Date	2:
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE		QA Closed:	Date	·
								<del></del>			QA Closed.	Date	•
Work Orde	or.					DISPOSITION			AGAIN	IST DE	PARTMENT	/PROCESS	
Work orac	_					Rework	7		Skid-tube Crosstu	ibe	]	Water Jet	Engineering
Part N	No.					Scrap	1	1	Machining Small F	-	Pro	d. Eng. Coor.	Quality
	-				<u>-</u>	Use-as-is	1	Thern	noforming Finish	ing	Rec/Sto	re/Packaging	Other
NCR N	No.					Work Order Update	]		Large Fab Compos	ite 🗌		Supplier	
							,	L					
Root					1	iption of work order update	1	Initial	Action		Sign &		
Cause	_	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data	Ш			Ì			•					1	
Equip/Tooling	Щ						ļ						
Operator	Ш												
Material	Ш												İ
Setup	Ш												
Other	Ш												
Process	Ш												
Supplier									•				
Training													
Unapproved						,					<u> </u>		
						F	AUI	T CATE	GORY				-
Landi	ng G	iear				General	_	-			-	_	
	Ш	Bending				Bend	L	Grain			Ovalized	L	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct [	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Ripples in Bend Torque Waves in Extrusion Countersink .

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde				*928	324*						Page 2
Item ID: Revision ID: Item Name:	D3913-041 Long Basket	Base Assemby, 350		Accept	*N900	<u>040</u>	100	)*	Setup Star Stop	1.71	S1* S2*
Start Date: Required Date: Reference:	11/09/12 11/28/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	ID:			- 0		
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:	_	]	Run Stai	!/	R1*
• •	QC:		Date:	_ SPC (Y/N):	D	ate:			Sto	*N	R2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC5- Inspect part compl	eteness to step on W/O	0.00							242
*120*		Memo		0.00				\	3.04.2M		DAS <b>09</b>
Quality Control											
125		Pressure Wash per QSI0	05 4.3	0.00						0-	

0.00

Memo

\*125\*
HandFinish

Hand Finishing

			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

										QA Closed:	Date	
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is Work Order Update	T	<b>N</b> herm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Init	ial	Act	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief	Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling												
Operator Material												
Setup												
Other	<b>,</b>		7									
Process .'												
Supplier										1		
Training		1										
Unapproved												
		9			F	AULT (	CATE	GORY				
Landir	ng Gear				General				_	_	_	<del></del>
	Bending				Bend	Gr	rain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to C	)/S	BOM/Route	$\vdash$	ardwa		_	Over/Under	<b>⊢</b>	Temperature/Cure
ļ	Cracks				Broken/Damaged	$\vdash$	-	on Incomplete		Part Incorre	<u> </u>	Weld
	Crushed/	Crimped.			Burrs	_		ons Incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	$\vdash$		nance	<u> </u>	Part Moved		
	Heat Trea			<u> </u>	Countersink	$\vdash$	islabe		_	Positioned V		<del>-</del> 1
	Inspection		Tube	<u> </u>	Cut Too Short	$\vdash$	isread			Power Loss/	Surge	Other
,	Ripples in				Drill Holes	$\mathbf{H}^{-1}$	fset					
	Torque W			<u> </u>	Drawing	<del></del>		alibration		<del></del>		
	Turning S				Finish	Mor	ut of S	equence				
l	Wave/Tw	ist in Tub	e		Folio	Ou	utside	Dimensions				

<b>Work Orde</b> November-09-12				*928	24*				Page 3
Item ID: Revision ID:	D3913-041			Accept	*N900040	<b>0100</b>	<b>)*</b> Seti	ıp Start	*NS1*
	Long Basket B	Base Assemby, 350						Stop	*NS2*
Start Date:	11/09/12	Start Qty: 1.00	*1*		Cust Item ID:				
Required Date: Reference:	11/28/12	Req'd Qty: 1.00	*1*		Customer:				
Approvals:	Process Pla	n:	Date:	Tooling:	Date:		Run		*NR1*
			Date:	SPC (Y/N):	Date:			Stop	*NR2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID Tool	# Plan Code	-		Reject Insp. Number Stamp
130		White Gloss(Ref:4.3.5.2)	per QSI005 4.3-Steel	0.00			1.		. 1 10 1 1
*130* Powdercoat		Memo		0.00			LXX	MI	13/04/2.
Powder Coating	069	coat	1E:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:LIPERATURE:	of hinge (3) prior to powder	****				
140 * <b>4 4 0</b> *		START TIM	IE:	0.00				d i	3-4-24

0.00

Memo

Quality Control

NCR:	Yes /	No				WORK ORDER NON-C	CO	NFORI	MANCE / UPI	DATE	QA Closed:	Date:	
Work Orde	or·		•.		<del>*</del>	DISPOSITION				AGAINST DE	PARTMENT		
Part N	 No					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	<del></del>	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			···		Descri	ption of work order update	ı	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved									,				
				_		<del></del>	AUL	T CATE	GORY				
Landi	ng Gea	7			r	General	_	1		_	· ¬		1
	$\vdash$	nding				Bend	-	Grain	•		Ovalized	<u> </u>	Pressure/Forced
	<del></del>		t Concer	ntric to	o/s  _	BOM/Route	$\vdash$	Hardwa		<u> </u>	Over/Under	<del></del>	Temperature/Cure
	Cracks					Broken/Damaged	-	l '	on Incomplete		Part Incorred	<b> </b>	Weld
	Crushed/Crimped					Burrs		1	ions Incomplete/L	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cu				<u> </u>	Contamination	-	Mainte		<u> </u>	Part Moved		
		at Treat		Tb =	<u> </u>	Countersink	$\vdash$	Mislabe		<u> </u>	Positioned V		l <sub>o.</sub> ,
'		-	Strip in	ıupe	-	Cut Too Short	-	Misread	<b>i</b> '		Power Loss/	Surge	Other
	<b>—</b>	ples in				Drill Holes	-	Offset	S. 144				•
	_	•	aves in E		n  -	Drawing	$\vdash$	1	Calibration				
	1 1 1 1 1 1	rning 🛰	CHENCE			I FINISh	1 1	It list of S	Annence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio -

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

\*160\*

Memo

Quality Control

170

Identify as per dwg & Stock Location 01020-016.00

\*170\*

Packaging

Memo

Packaging

0.00

1 d BL B-4-2L

											DQA	: Date	:
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UPI	DATE			
<del>,</del>						<b>,</b>					QA Closed	: Date	•
Work Ord	er:					DISPOSITION				AGAINST DI	PARTMEN	T/PROCESS	
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining noforming  Large Fab	Crosstube Small Fab Finishing Composite	→)	Water Jet od. Eng. Coor. ore/Packaging Supplier	Engineering Quality Other
Root			1		Descri	Lotion of work order update	T	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	,	or Non-conformance		nief Eng		ription	Date	Verification	QC Inspector
Doc/Data			Осор				+ -		2 555.	· pero.			
Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	c/Data lip/Tooling erator terial up ner ocess oplier ining									·			·.
							AUI	LT CATE	GORY				
Landi	_	1				General		-			<del>-</del>	-	<del></del> 1
	L	Bending			<u> </u>	Bend		Grain			Ovalized		Pressure/Forced
	Centre Not Concentric to O/S					BOM/Route	L	Hardwa	re		Over/Unde	r tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete	L	Part Incorre	ect	Weld
Crushed/Crimped_						Burrs	L	Instructi	ions Incomplete/U	Jnclear	Part Lost/N	lissing	Wrong Stock Pulled
		Cuffs				Contamination	$\perp$	Mainte	nance		Part Moved	1	
		Heat Trea	t			Countersink		Mislabe	led		Positioned	Wrong	_
		Inspection	n Strip in	Tube		Cut Too Short		Misread	l.		Power Loss	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Work Ord November-09-1				*928	324*							Page 5	
Item ID: Revision ID: Item Name:	D3913-041 Long Basket	Base Assemby, 350		Accept	*N900	<b>040</b>	100	<b>)*</b> s	Setup S	tart top	ı Vı .	S1* S2*	
Start Date: Required Date Reference:	11/09/12 : 11/28/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					,		
Approvals:	Process Pl	an:	Date:	Tooling:	Da	nte:		F		tart	*N	R1*	
Approvals:	QC:		Date:	<b>SPC (Y/N):</b>	Da	ate:			S	top	*N	R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp	
180		QC21- Final Inspection	- Work Order Release	0.00					1/2	.1.	/ l-	5 db)	
*180* QC Quality Control		Memo		0.00					17	45	2 /-	NF .	
											(	NUF 4-24	)

												DQA:	Date	<u>:</u>
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UF	PDATE		•		
						·						QA Closed:	Date	2:
Work Ord	er.					DISPOSITION				AGAINS	T DE	PARTMENT	/PROCESS	
Part I	- No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining noforming Large Fab	Crosstub Small Fa Finishin Composit	b g	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ad	tion		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	cription		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
						F	AUL	T CATE	GORY					
Landi	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instructi Mainte Mislabel Misread	on incomplete ions incomplete, nance led	/Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	l (1	Ripples in	Bend			Drill Holes	1	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

November-09-12 1:37:33 PM

Work Order ID:

92824

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

**Start Date:** 11/09/12

Required Date: 11/28/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC

	verified by:EC	II I KI	V.C 12	2.07.24 AST	ER DWG REV.	D DD VERG					<del>-</del>		<del></del>
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A		Purchased	No			150	Each	227.0000	6	6	mld	485	88
Bolt									<del></del>			1-0-2	
				<b>Location</b>		Loc Qty	<u>L</u>	oc Code					
				ST512		227							
					0873	17							
				12	2800	210							
N960JD8 Vasher	NAS1149DN832J	Purchased	No			150	Each	0.0000	2	2	ml	232	488 3.04.2
2581		Manufactured	No			100	Each	86.0000	2	2		0 1	•
Mounting Bracket		Manufactured							73.9	8503	<b>→</b> 2⁄_	SYI	3.04.2
				<b>Location</b>		Loc Oty	<u>L</u>	oc Code					
				WA		83							
				82	506	2							
				83	230	3							
					452	2			<del></del>				
					367	39							
					706	2							
					574	35				<del></del>			
				WA005		3							
					766	2				<del></del>			
				81	253	1							
D2931 Bumper	•	Manufactured	No			150 .	Each	2,306.000	2	2	80	13-0	1-24.
-				Location		Loc Qty	L	oc Code					
				ST021		2306							
					064	308				_) X			
				86	435	1998							

						·					DQ	A:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE	QA Close	q. 	Date:	
						DISPOSITION				AGAINST D		IT/PROCESS	oute.	
Work Ord Part I	No.					Rework Scrap Use-as-is Work Order Update		! Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	] . P	Water J rod. Eng. Coo tore/Packagi Suppli	or. ng	Engineering Quality Other
Root			•		Descri	ption of work order update		Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verifica	tion	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
							AUI	LT CATE	GORY		·		·	
Landi		Gear Bending Centre No Cracks Crushed/0		ntric to	o/s	General Bend BOM/Route Broken/Damaged Burrs		<b>-</b> 1 '	re on Incomplete ions Incomplete/	Unclear	Ovalized Over/Und Part Incor	•		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Cuffs Heat Treat Inspection Strip in Tube					Contamination Countersink Cut Too Short		Mainte Mislabe Misread	led		Part Move Positioned Power Los	d Wrong		Other
	1 1	Ripples in	Rend		I	Drill Holes	1	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-09-12 1:37:33 PM

Work Order ID:	92824								
Parent Item:	D3913-041						Sta	rt Date: 11/09/12	Required Date: 11/28/12
Parent Item Name:	Long Basket Base	Assemby, 350					Sta	rt <b>Qty:</b> 1.00	Required Qty: 1.00
<b>D3913-1</b> Rib		Manufactured	No		100	Each	8.0000	. 1	1 CA13.4.22
				Location	Loc Oty		Loc Code	B.	14826 0
				WA	7				_
				74145	0			<del></del>	
				88463	5				_
				88639	2				_
				WA006	1				_
				87543	1				- 0
D3913-15 Wide Handle Plate		Manufactured	No		100	Each	7.0000	1	1 (p(134.22 390084 -> (1)
				Location	Loc Oty		Loc Code		B90084 <del>-&gt; (1)</del>
				WA	7				
				87011	3			-	<u>_</u>
				90084	4			•	
D3913-3		Manufactured	No		100	Each	13.0000	. 1	1 /2/12/12
Rib	• .							( ) de 7 7 7 70 700 700	CPC 13.4.00
				Location	Loc Qty		Loc Code		B94165(1
				WA	12				_
				69160	0				
				74144	0				
			,	84651	1				<u></u>
				87500	. 1				_
				88443	. 10			<del></del> .	<u> </u>
				WA006	. 1				
				69160	1				_ //
D3913-7		Manufactured	No		100	Each	14.0000	2	2 Vol. 7.4.22
Rib									0.5-15-5
				Location	Loc Oty		Loc Code		B88492-5
				WA	14				
	•			88491	8		-		
				88493	6				

									DQA:	Date:	<del></del>
NCR: Yes	s / No			WORK ORDER NOI	N-CONF	ORM	IANCE / UP	DATE	QA Closed:	Date:	
Work Order:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No.	· · · · · · · · · · · · · · · · · · ·			Rework Scrap		M	Skid-tube 1 Skid-tube 1	Crosstube Small Fab	1 '	Water Jet d. Eng. Coor.	Engineering Quality
ÑCR No.	•	\$		Use-as-is Work Order Update			oforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Description of work order update	e Init	ial	Act	tion	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief	Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling											
Operator											
Material						İ				;	
Setup'						1					
Other											
rocess	1										
Supplier	]									·	
raining	1										
Inapproved	1								1		

FAULT CATEGORY

**Landing Gear** General Bend Pressure/Forced Bending Grain Ovalized BOM/Route Centre Not Concentric to O/S Over/Under tolerance Temperature/Cure Hardware Broken/Damaged Weld Cracks Inspection Incomplete Part Incorrect Crushed/Crimped. Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

November-09-12 1:37:34 PM

Work Order ID:	92824							
Parent Item:	D3913-041	*		•		Start	Date: 11/09/12	Required Date: 11/28/12
Parent Item Name:	Long Basket Base Assemby, 350					Star	rt Qty: 1.00	Required Qty: 1.00
<b>D3913-9</b> Hinge Rib	Manufactured	No		100	Each	7.0000	1	1 CpC13.4.20
			Location	Loc Qty		Loc Code	3	97674——
			WA006	. 7				_
			70138	1			•	_
			88215	6				
D3916-041 Rib Assembly	Manufactured	No		100	Each	6.0000	2	2 (pc/3.4.22 394818()
-			Location	Loc Qty		Loc Code	I	394818()
			WA	4				_
	•		88657	4				_
			WA006	2				
			81444	2				
D3916-5	Manufactured	No		100	Each	20.0000	3	3 (10/12/1/25
Light Rib	Manufactured							· CPC/3.4.00
			Location	Loc Qty		Loc Code		394698 ->
			WA	20				_
			77142	1				_
			82933	4				_
			86533	5			· 	_
			88665	10				- 0
D4016-1 Hinge Half, Base	Manufactured	No		100	Each	25.0000	3	3 6613.4.22 355098
			Location	Loc Oty		Loc Code		399098-
			WA	25				' '
			66418	. 0				<del>-</del> ·
			88175	7				_
			88790	18				=

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE			<u> </u>		
											_	QA Closed:	Da	te:	
Work Ord	er.					DISPOSITION				AGAINST D	PARTMENT	PROCESS		-	
Part I	No.			· · · · · · · · · · · · · · · · · · ·		Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier				Engineering Quality Other	
Root					Descri	ption of work order update		Initial	Act	tion	I	Sign &			
Cause		Date	Step	Qty	. (	or Non-conformance	Cł	nief Eng	Desc	ription		Date	Verificatio	U	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
						F	AUI	T CATE	GORY		_				
Landi	ng (	Gear				General	_	,		_	_	1			T
		Bending Centre No Cracks Crushed/			O/S	Bend BOM/Route Broken/Damaged Burrs		Instructi	on Incomplete ions Incomplete/	Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi	ct		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	-	Cuffs Heat Trea	t		-	Contamination Countersink	-	Mainte Mislabe				Part Moved Positioned W	Vrong		
		Inspection	n Strip in	Tube		Cut Too Short Drill Holes		Misread Offset				Power Loss/:	_		Other

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-09-12 1:37:34 PM

Work Order ID: Parent Item:	92824 D3913-041					Start	Date: 11/09/12	Required Date: 11/28/12
Parent Item Name:	Long Basket Base Assemby, 350					Start	<b>Qty:</b> 1.00	Required Qty: 1.00
<b>D4017-7</b> Rib	Manufacture	ed <sup>No</sup>		100	Each	6.0000	1	1 (pl/3.4.22
			Location	Loc Qty		Loc Code	Ē	395/02-
			WA	4			, •	
			82969	1				
			88391	3				
			WA005	2				
			69730	1				
			85435	1				
<b>94017-9</b> Lib	Manufacture	ed No		100	Each	11.0000	2	2 CpL 13.4.22
			<b>Location</b>	Loc Oty		Loc Code		爭95≥03~>>
			WA	9				
			81445	1				•
	•		88671	8				-
			WA006	2				
			70341	2				
04020-11 End Mesh, Basket	Manufacture	ed <sup>No</sup>		100	Each	17.0000	2	2 CpC13.4.20
na wesi, basket			Location	Loc Qty		Loc Code		B 94553 ->
			WA .	17				
			81442	2				-
			84972	1			· · · · · · · · · · · · · · · · · · ·	-
•			88260	14				-

											DQA:	Date	•		
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	AANCE / UPI	DATE					
,								,			QA Closed:	Date	<u> </u>		
Work Ord	er.					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part I	No.	,				Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root		·			Descri	ption of work order update		Initial	Act	ion	Sign &				
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
						_	AUL	LT CATE	GORY	<del></del>					
Landi	Centre Not Concentric to O/S Cracks Br Crushed/Crimped Cuffs Heat Treat Co				o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread			Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \( \) Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	Ripples in Bend Drill Holes							Offset		<del></del>	_	_			

Out of Calibration

Out of Sequence
Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-09-12 1:37:34 PM

Work Order ID:	92824						•	
Parent Item:	D3913-041				•	Start	Date: 11/09/12	Required Date: 11/28/12
Parent Item Name:	Long Basket Base Assemby, 350					Start	<b>Qty:</b> 1.00	Required Qty: 1.00
<b>D4021-1</b> Handle Plate	Manufactured	No	·	100	Each	50.0000	3	3 (pl 13-4.2)
			Location	Loc Oty		Loc Code		B98356-
			WA	50			_	
			69518	0				B95039->-(
			74316	0				<b>—</b>
			74946	0				
			87330	20				
,			88323	8				
			88849	10				
			89204	12				
04021-5	Manufactured	No		150	Each	50.0000	2	2
Blanking Plate	.,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,							
			<b>Location</b>	Loc Qty		Loc Code		/ \
						<u>Loc Couc</u>		
			ST084	50				
			85065	2				
			88151	22			<del></del>	BD 13-4-24.
			89059:	26				
04034-041 Aft Upper Rib Assembly	Manufactured	No		100	Each	5.0000	1	1 Pp13-4-22
			Location	Loc Qty		Loc Code	39	3187
			WA	5				
			84048	1				•
			90284	4				
24024.042		NI.	7020 <del>4</del>	100	Cook	6 0000	1	
<b>04034-043</b> Fwd Upper Rib Assembl	Manufactured y	No		100	Each	6.0000	1	B94490->
			<b>Location</b>	Loc Qty		Loc Code		B94490-
			WA	6				, , , , ,
			82980	2				-
			89088	1			Ad-20-0-	-
			90281	3			<del> </del>	-

				DQA:	Date:		
NCR: Yes / No	WORK ORDER NON-CO	NFORMANCE / UI					
		· · · · ·		QA Closed:	Date:		
Work Order:	DISPOSITION		AGAINST DEF	ARTMENT/PRO	CESS		
	Rework	Skid-tube	Crosstube	W	ater Jet	Engineering	
Part No.	Scrap	Machining	Small Fab	Prod. En	g. Coor.	Quality	
	Use-as-is	Thermoforming	Finishing	Rec/Store/Pa	ckaging	Other	
NCR No	Work Order Undate	Large Fah	Composite	•	Supplier		l i

Initial

Chief Eng

Action

Description

Sign &

Date

Verification

QC Inspector

Description of work order update

or Non-conformance

## Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bend Bending Pressure/Forced Grain Ovalized BOM/Route Centre Not Concentric to O/S Over/Under tolerance Temperature/Cure Hardware Broken/Damaged Cracks Inspection Incomplete Part Incorrect Weld Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend **Drill Holes** Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio **Outside Dimensions**

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Step

Date

Qty

Root

Cause
Doc/Data
Equip/Tooling

November-09-12 1:37:35 PM

92824 Work Order ID: Required Date: 11/28/12 **Start Date:** 11/09/12 Parent Item: D3913-041 Required Oty: 1.00 Start Qty: 1.00 Parent Item Name: Long Basket Base Assemby, 350 D4672-1 No 100 Each 18.0000 Manufactured Blanking Plate Loc Oty Loc Code Location WA 18 8 88253 92497 10 33 No 100 sf 1,192.3113 M304EX0.75-16F Purchased **Expanded Metal Flat SS** Loc Code Loc Qty Location WA 320 123448 320 WA035 872.3112637 117197 102.9036 120917 50.88673 121521 0.00013372 122080 63.0699 122315 11.245 122534 274.2 79.438 122604 122884 36.5679

254

123200

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		· <del></del>	
					-	, ·		<b>T</b>			QA Closed:	Date	·
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part I	. No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
l and:		<u> </u>	•			General F	AUL	T CATE	JORY	<del> </del>			
Landi		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W	Crimped. t n Strip in Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instructi Mainte Mislabe Misread Offset	on incomplete ions incomplete/ nance led	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-09-12 1:37:35 PM

Work Order ID: 92824 **Start Date:** 11/09/12 Required Date: 11/28/12 Parent Item: D3913-041 Required Qty: 1.00 Long Basket Base Assemby, 350 Start Qty: 1.00 Parent Item Name: 150 1,419.0000 MS20600-AD4W3 No Each Purchased Cherry Rivets Location Loc Oty Loc Code 311 136 122452 136 ST311 462 462 123525 ST314 217 122151 217 ST321 471 111636 36 117601 3 200 118626 120308 232 133 WA018 133 107939 MS21042L3 No 150 Each 2,433.0000 Purchased Nut Loc Code Location Loc Qty 316 619 122452 619 ST300 225 117885 32 55 119017 119075 138 ST314 1268 123265 1268 ST317 321 122141 321

NCR:	⁄es	/ No				V	ORK ORDER NON-C	O	NFORM	MANCE /	UPD.	ATE	·			
												3-2-	QA Closed:	Date:		
Work Orde	er:			_			DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part f	•		,				Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab		Crosstube Small Fab Finishing Composite	Prod Rec/Stor	Engineering Quality Other		
Root		·			Desc	riptio	n of work order update	ı	nitial		Actic	on	Sign &			
Cause		Date	Step	Qty		or No	on-conformance	Ch	ief Eng		Descrip	otion	Date	Verification	QC Inspector	
oc/Data		1	,		:				-							
perator																
/laterial									:							
etup																
ther																
rocess													,			
upplier																
raining																
Inapproved																
							F/	AUL	T CATE	GORY						
Landi	ng G	ear					General						_		_	
		Bending				Ber	nd		Grain			:	Ovalized		Pressure/Forced	
		Centre No	t Concen	tric to (	o/s	ВО	M/Route		Hardwa	re			Over/Under	tolerance	Temperature/Cure	
		Cracks				Bro	ken/Damaged		Inspecti	on Incompl	ete		Part Incorred	ct	Weld	
		Crushed/C	Crimped.			Bur	rs		Instruct	ions Incomp	olete/Ur	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
		Cuffs				Con	ntamination		Mainte	nance			Part Moved		_	
		Heat Treat	t			Cou	untersink		Mislabe	led			Positioned V	Vrong		
		Inspection	Strip in	Tube	Γ	Cut	Too Short		Misread				Power Loss/	Surge	Other	
		Ripples in	Bend			Dri	ll Holes		Offset							
		Torque W	aves in E	xtrusion	٦	Dra	awing		Out of 0	Calibration						
		Turning Se	equence			Fini	ish		Out of S	equence						
	Wave/Twist in Tube Folio						io		Outside	Dimension	s					

DQA:

Date:

November-09-12 1:37:35 PM

Work Order ID:

92824

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

NAS1149F0332P

WASHER

Purchased

No

**Start Date:** 11/09/12

Required Date: 11/28/12

Start Qty: 1.00

Required Qty: 1.00

1,182.0000 12 m/23900

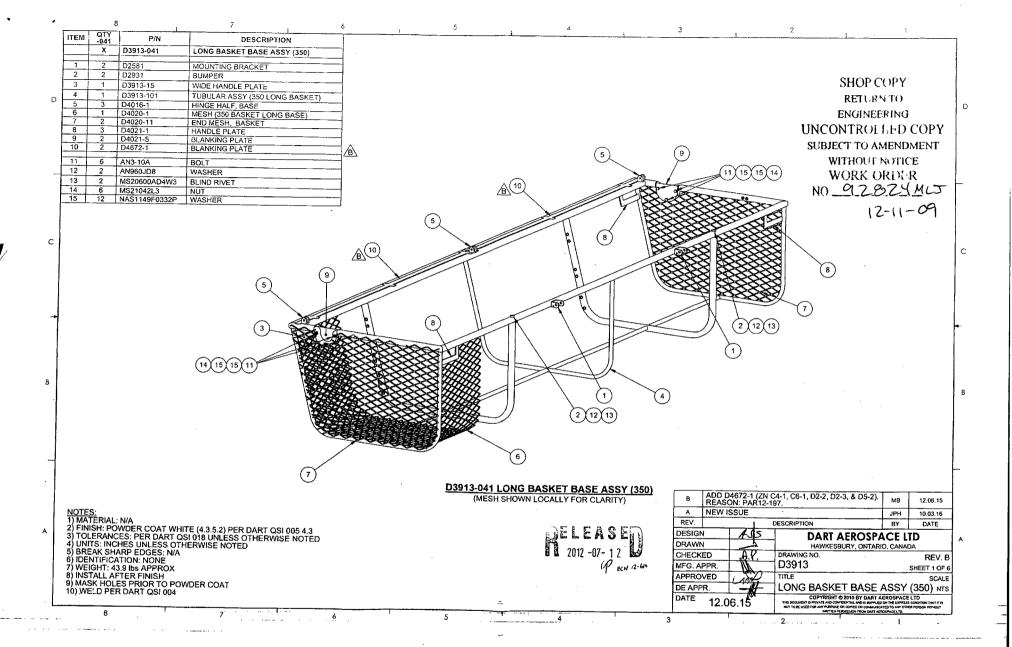
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275	206		
122441	206		**************************************
ST275	776		
117735	13		
119225	8		
121259	138		
121825	14		
122063	600		
17317	3		
ST295	200		
123352	200		

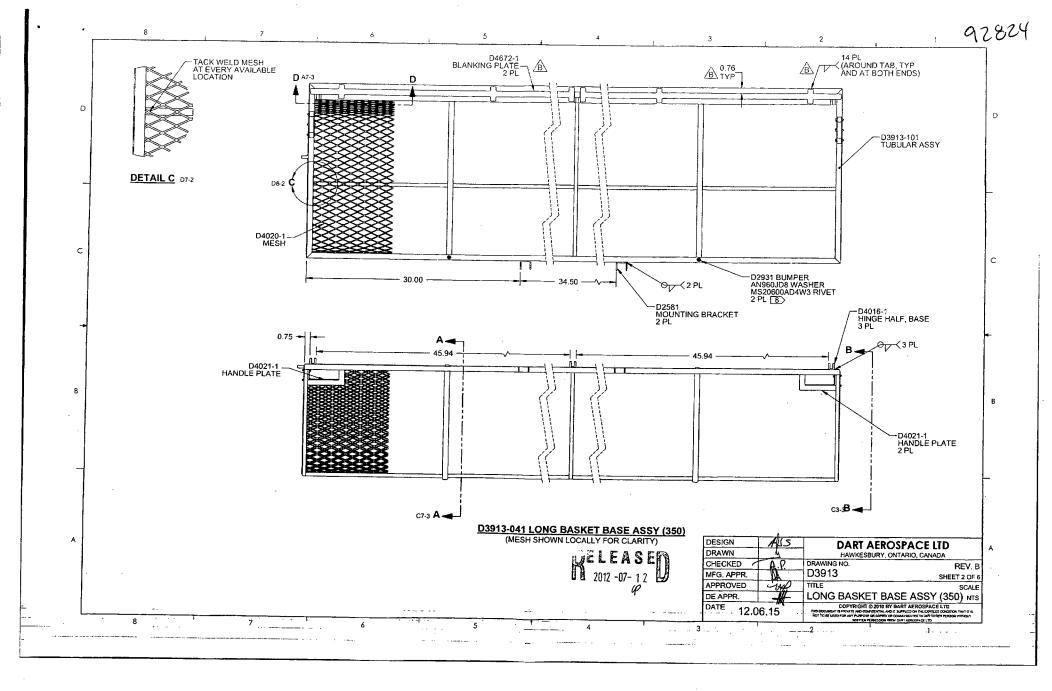
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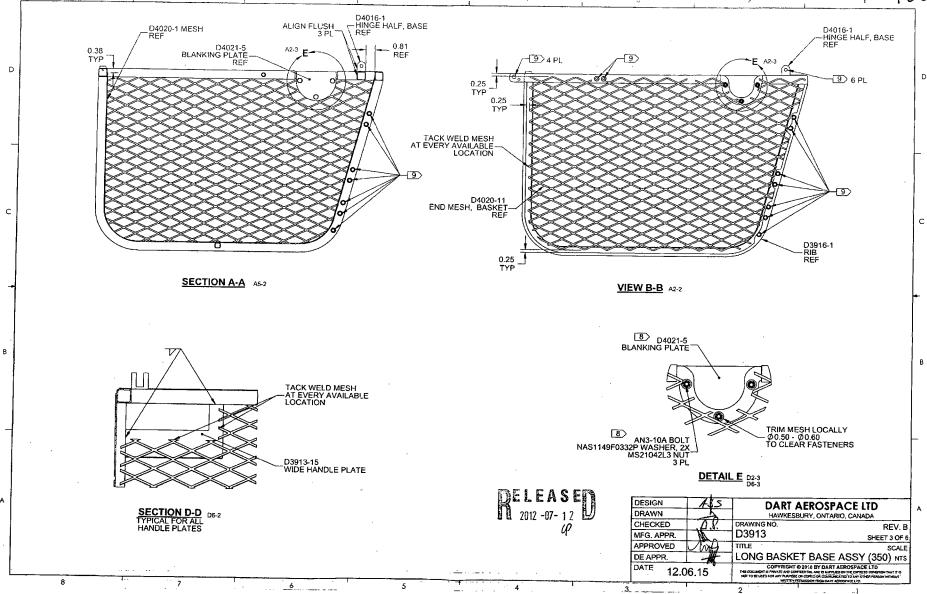
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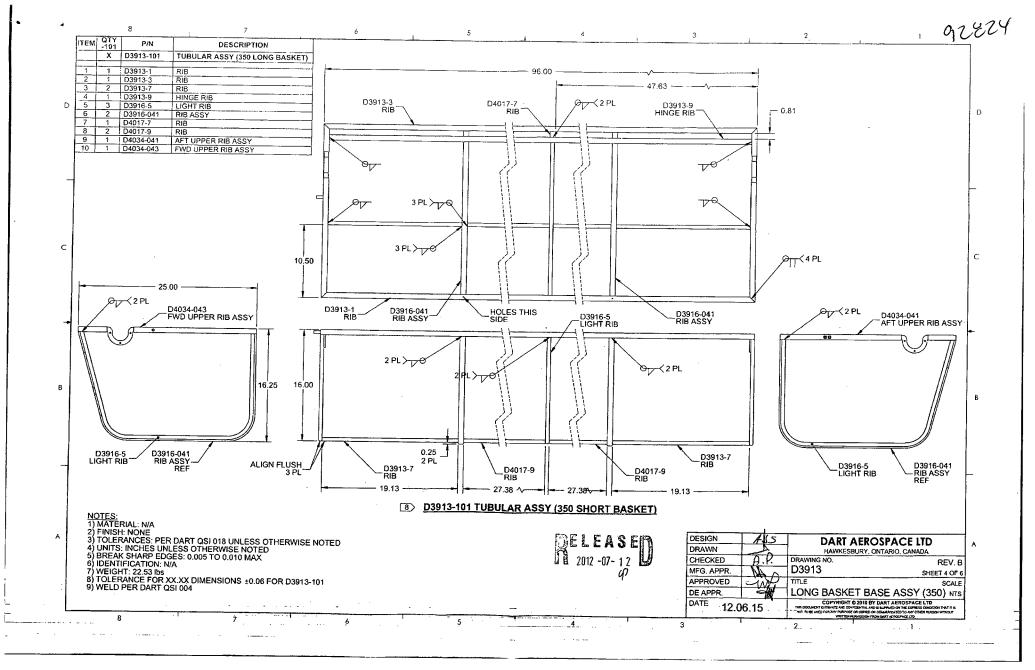
		DQA:	Date:	
ICR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

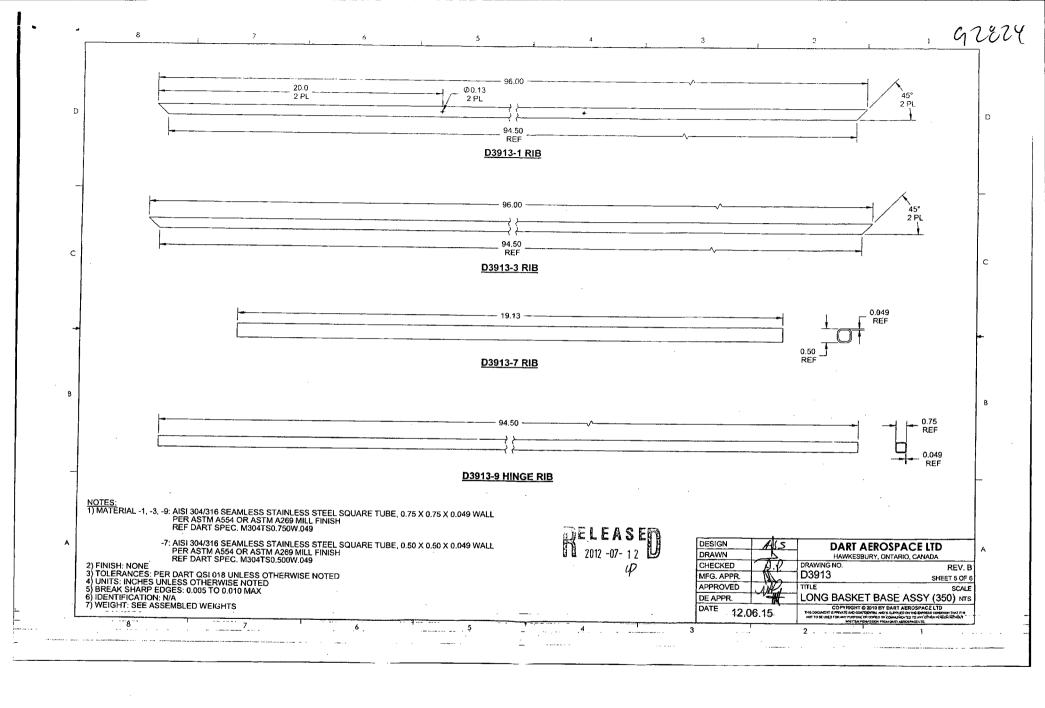
								·		QA Closed:	Date	•
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No.					Rework Scrap Use-as-is		Machining Small Fal		Crosstube Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
NCR No.					Work Order Update			Large Fab	Composite	]	Supplier	
Root				Descri	cription of work order update		Initial Action		ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier										1		
Training	_											
Unapproved		<u> </u>				<u> </u>			- · - · · <u>-</u> · · · · · · · · · · · · · · · · · · ·	<u> </u>		
FAULT CATEGORY												
Landin	<del></del> 1				General				<del></del>	7	_	<del></del> 1
1	Bending				Bend	Grain		<u> </u>		Ovalized		Pressure/Forced
1	Centre No	ot Concer	itric to (	D/S	BOM/Route	Hardware				Over/Under	<u> </u>	Temperature/Cure
	Cracks			_	Broken/Damaged	-	Inspection Incomplete		<u> </u>	Part Incorrect		Weld
L	Crushed/Crimped.				Burrs	_		ions Incomplete	/Unclear	Part Lost/Missing		Wrong Stock Pulled
	Cuffs				Contamination	Mainter				Part Moved		
	Heat Trea			_	Countersink	Mislabele				Positioned Wrong		· ¬
Ĺ	Inspection		Tube		Cut Too Short	-	Misread	i	L	Power Loss/	Surge	Other
1	Ripples in Bend				Drill Holes	-	Offset					•
<u> </u>	Torque Waves in Extrusion				Drawing	$\vdash$	Out of Calibration					
1	- ' ' <del> </del>				Finish		Out of Sequence					
	Wave/Twist in Tube				Folio	1 1	Outside Dimensions					



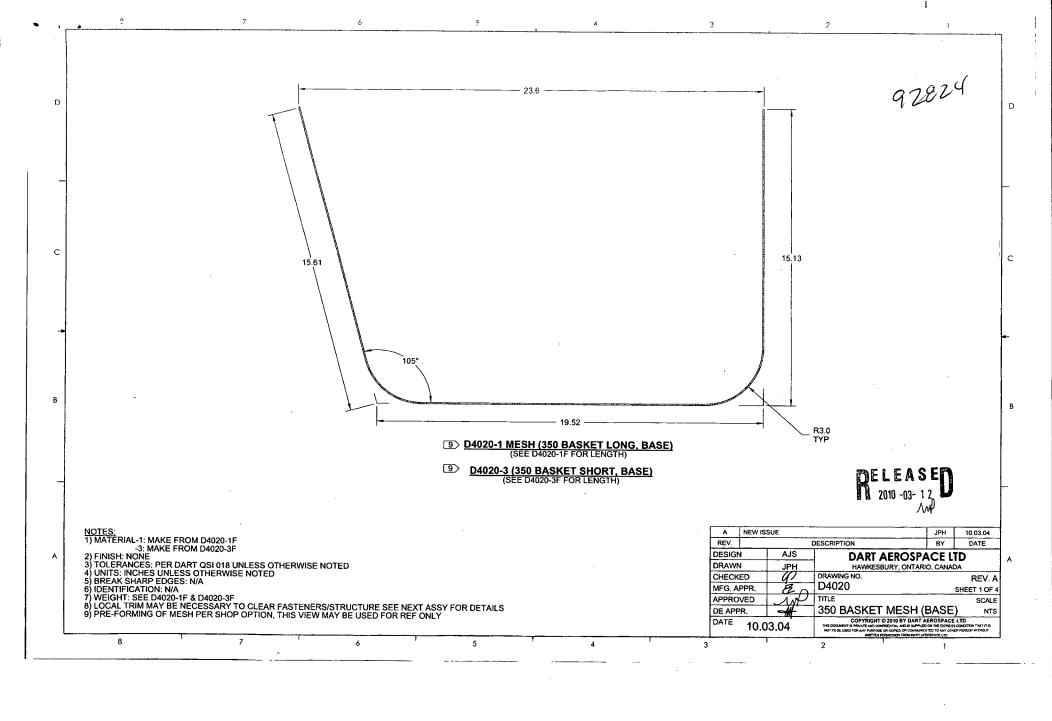








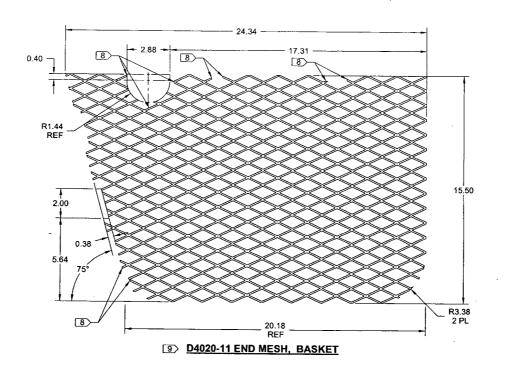
D 0.75 С C R0.06 TYP 3.00 1.50 \_\_ 0.13 REF **D3913-15 WIDE HANDLE PLATE** NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs ELEASED 2012 -07- 12 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3913 MFG. APPR. SHEET 6 OF 6 APPROVED TITLE DE APPR. LONG BASKET BASE ASSY (350) NTS DATE 12.06.15 3



D4020-5: 95.25 D4020-7: 56.00 21.75 2.00 1.25 D4020-7 D4020-5 25.00 44.66 9 <u>D4020-5 MESH (350 BASKET LONG, LID)</u> (LOCAL SECTION MESH SHOWN FOR CLARITY) 9 D4020-7 MESH (350 BASKET SHORT, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY) NOTES: 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06. DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 2 OF 4 TITLE APPROVED SCALE 350 BASKET MESH (BASE) DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD

PRISOCOLIENT OF PRIVATE AND COMPERENTIAL AND IS SUPPLED ON THE ERPRESS CONDITION THAT IT NOT TO SE USED FOR ANY PURPOSE OF COMPERENT AND TO DAY OTHER PURPOSE AND THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF THE PRIVATE OF DATE 10.03.04



NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F

8

REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 lbs
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4020 MFG. APPR. SHEET 3 OF 4 APPROVED TITLE SCALE 350 BASKET MESH (BASE) DE APPR. NTS DATE 10.03.04 COPYRIGHT © 2010 BY DART AEROSPACE LTD
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